

Work Order ID 131706

Tuesday, April 21, 2015 1:47:15 PM

131706

Page 1

Item ID: D412-709-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Escape Panel Push-Out Window Clear Fits LH or RH
 Start Date: 4/16/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 1504-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-709-013		CHG001						
						DAS 27 9-89			
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
							DAS 6 9-89		
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
							DAS 27 9-89		

OCT 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
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Work Order ID 131706

Tuesday, April 21, 2015 1:47:15 PM

131706

Page 2

Item ID: D412-709-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Escape Panel Push-Out Window Clear Fits LH or RH

Start Date: 4/16/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/20/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-709-013

Location:

PPP Rev:

PPP137932

DAS
6
9:59

OCT 19 2015

DAS
28

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS

OCT 19 2015

MCS OCT 19 2015

DQA: _____ Date: _____



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Picklist Print

Tuesday, April 21, 2015 1:47:15 PM

Page 1

Work Order ID: 131706

131706

Parent Item: D412-709-013

D412-709-013

Parent Item Name: Escape Panel Push-Out Window Clear Fits LH or RH

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-05-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3136-043		Manufactured	No			110	Each	1.0000	1	1			
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D3136-043

Window Assembly

BAS
27
9-89

Location	Loc Qty	Loc Code
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ST435	1	
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130203	1	
--------	---	--

D3237-1		Manufactured	No			110	f	373.0000	8.1666	9			
---------	--	--------------	----	--	--	-----	---	----------	--------	---	--	--	--

D3237-1

Seal Retainer(\$ Per Ft)

BAS
27
9-89

Location	Loc Qty	Loc Code
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ST420	73	
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120345	13	
--------	----	--

121811	48.7	
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128277	11.3	
--------	------	--

ST430A	300	
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128283	300	
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D3237-3		Manufactured	No			110	f	424.0000	8.166	9			
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D3237-3

Seal Filler(Price Per Ft)

BAS
27
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST421	1	
-------	---	--

121358	1	
--------	---	--

st640	423	
-------	-----	--

123981	423	
--------	-----	--

DAS
6
9-89

DAS
28

DAS
6
9-89

DAS
28

OCT 19 2014

DAS
6
9-89

DAS
28

132518

134745

134745

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D412-709-013

Parent Item Name: Escape Panel Push-Out Window Clear Fits LH or RH

Start Date: 4/16/15

Required Date: 4/20/15

Start Qty: 1.00

Required Qty: 1.00

D3561-1

Manufactured No

110

Each

7.0000

1

1

D3561-1

Seal Insert Tool

131940

DAS
6
9-89

DAS
28

Location

Loc Qty

Loc Code

ST049

7

117162

7

DAS
27
9-89

OCT 19 2015

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